

Work Order ID 70502

Friday, June 10, 2011 9:59:41 AM



Page 1

Item ID: D4403-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Bracket Inboard, RH

Start Date: 6/14/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 2.00



Customer:

Reference:

June 11/06-10

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4403

A

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

*aml 11/06/13**2 0*

Jeaspa Bandsaw

CUT BLANK AT 3.150"

110

0.00



HAAS 1

Memo

0.00

*aml 11/06/12**2 0*

HAAS CNC vertical machine #1

MACHINE AS PER DWG & FOLIO FB059,
FOLIO REV: *AA*
DWG REV: *A*

DEBURR

Work Order ID 70502

Friday, June 10, 2011 9:59:42 AM



Page 2

Item ID: D4403-4

Accept



Setup Start



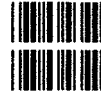
Revision ID:

Stop



Item Name: Aft Bracket Inboard, RH

Start Date: 6/14/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

mr 11/06/23

2

0



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

DFJ 11/06/24

2

0



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

2

BL 11-6-24



HandFinish

Memo

0.00

Hand Finishing

Work Order ID 70502

Friday, June 10, 2011 9:59:42 AM



Page 3

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Setup Start



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Start Date: 6/14/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2x D M-14/06/24

160

Identify as per dwg & Stock Location: ST139G

0.00



Packaging

Memo

0.00

Packaging

JB (2) 11/06/24

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/06/24

MF

11-06-24

Picklist Print

Friday, June 10, 2011 9:59:38 AM

Page 1

Work Order ID: 70502



Parent Item: D4403-4



Parent Item Name: Aft Bracket Inboard, RH

Start Date: 6/14/2011

Required Date: 6/23/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV: A NEW ISSUE 11/06/08 JFS VERIFY BY:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T73B01.250X03. 000		Purchased	No				f	12.0000		0.547368			



7075-T73 BAR 1.250" X 3.000"

Location

Loc Qty

Loc Code

MAT008

12

117942

12

547 on 11/06/13

DART AEROSPACE LTD		Work Order: 70502
Description: AFT BRACKET INBOARD, RH		Part Number: D4403-4
Inspection Dwg: D4403 Rev: A		Page 1 of 1

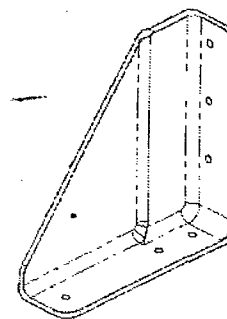
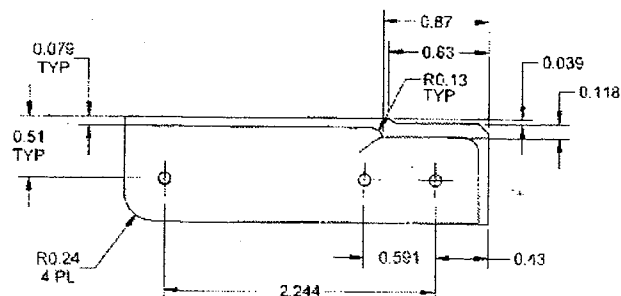
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.079	$\pm .010$.082	—		Vern	HL-7
.57	$\pm .030$.573	—		"	"
2.244	$\pm .010$	2.244	—		"	"
.591	$\pm .010$.591	—		"	"
.43	$\pm .030$.436	—		"	"
.118	$\pm .010$.120	—		"	"
.039	$\pm .010$.039	—		"	"
.83	$\pm .030$.824	—		"	"
.87	$\pm .030$.875	—		"	"
2.95	$\pm .030$	2.955	—		"	"
3.012	$\pm .010$	3.014	✓		"	"
.866	$\pm .010$.866	—		"	"
.43	$\pm .030$.427	—		"	"
.98	$\pm .030$.983	—		"	"
.827	$\pm .010$.827	—		"	"
1.654	$\pm .010$	1.654	—		"	"
Ø.098	$\pm .004$ $\pm .001$	Ø.098	—		"	"

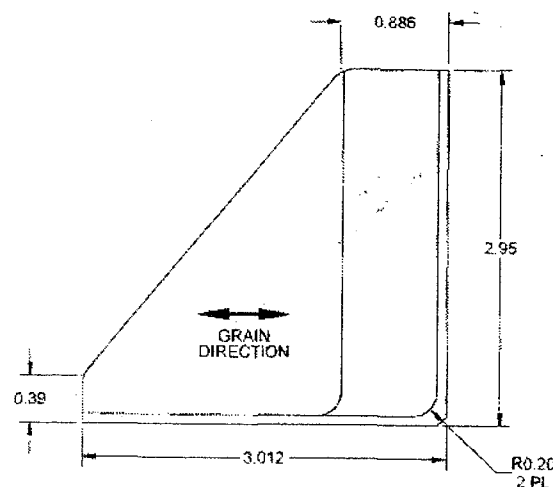
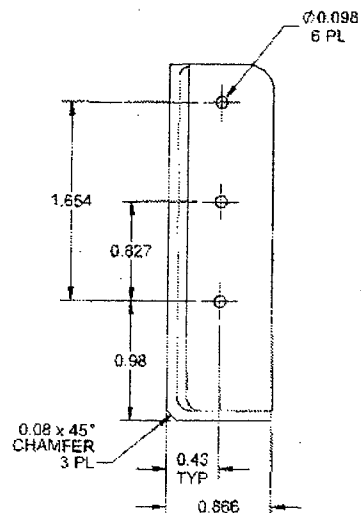
Measured by: <i>aml</i>	Audited by: <i>DFB</i>	Preliminary Approval:
Date: 11/02/23	Date: 11/06/24	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	<i>[Signature]</i>

[Signature] 10.04.15



w/o 705 02



D4403-4 AFT BRACKET INBOARD, RH

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM BAR
AMS-QQ-A-250/12 (AMS 4078)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.10 lbs
- 8) SIMILAR TO AGUSTA P/N 3G2591A07251

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV A
MFG. APPR.	<i>[Signature]</i>	D4403	SHEET 4 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
DATE	11.05.18	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED ONLY FOR THE PURPOSES SPECIFIED IN THE TITLE AND SCALE. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.</small>	

RELEASED
2011-05-24
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